

Date: Monday, 2/19/2007 8:07:20 AM
 User: Kim Johnston

Process Sheet

| | |
|---|---------------------------------------|
| Customer : CU-DAR001- Dart Helicopters Services | Drawing Name : PLATE |
| Job Number : 30744 | |
| Estimate Number : 12669 | |
| P.O. Number : <u>N/A</u> | Part Number : D323833 |
| This Issue : 2/19/2007 S.O. No. : <u>N/A</u> | Drawing Number : D3238 REV B |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : <u>N/A</u> Type : SMALL /MED FAB | Drawing Revision : B |
| Previous Run : 30688 | Material : <u>N/A</u> |
| Written By : _____ | Due Date : 2/26/2007 Qty: 16 Um: Each |
| Checked & Approved By : <u>07.02.19</u> | |
| Comment : Est Rev:A New Issue 07-01-26 JLM | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|-------------|--------------------|
| 1.0 | M6061T6S020 | 6061-T6 .020 Sheet |
|-----|-------------|--------------------|



Comment: Qty.: 0.0252 sf(s)/Unit Total : 0.4032 sf(s)

6061-T6 .020 Sheet

Batch: M 48945052-0.20

| | | |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET

1-Cut as per Dwg D3238

Dwg Rev: BProg Rev: Bml 07 02 20

(16)

2-Deburr if necessary

Use cutting file D3238-21-23-25**

SAD 07/02/19 (16) P/B

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|

ml 07 02 20

(16)



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/04/19 (16)

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

07/02/20 (16)

| | | |
|-----|-----------------|----------------------------|
| 5.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
|-----|-----------------|----------------------------|




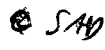




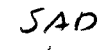



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

07-02-20 (16)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 07/02/22
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|----------|------|--|---|---------------------------------|---|---|---|---|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 07/02/19 | 2.0 | the orifice had to be change so 2 piece were Scrap |  | Scrap & destroy replace |  07/02/19 |  |  |  |
| 07/02/19 | 2.0 | Scrap 16 parts holes were out of tolerance program error |  | Scrap & destroy |  07/02/19 |  |  |  |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Monday, 2/19/2007 8:07:20 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLATE

Job Number: 30744

Part Number: D323833

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PC 7/2/21 (14)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

J PC 7/2/21 (14)

8.0

QC21

FINAL INSPECTION W/O RELEASE



Comment: FINAL INSPECTION W/O RELEASE

16
2/20/20

Job Completion



W 07-02-27

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

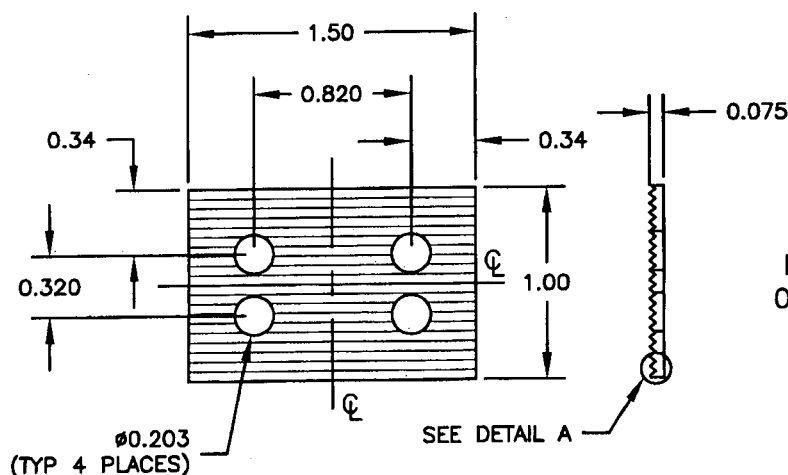
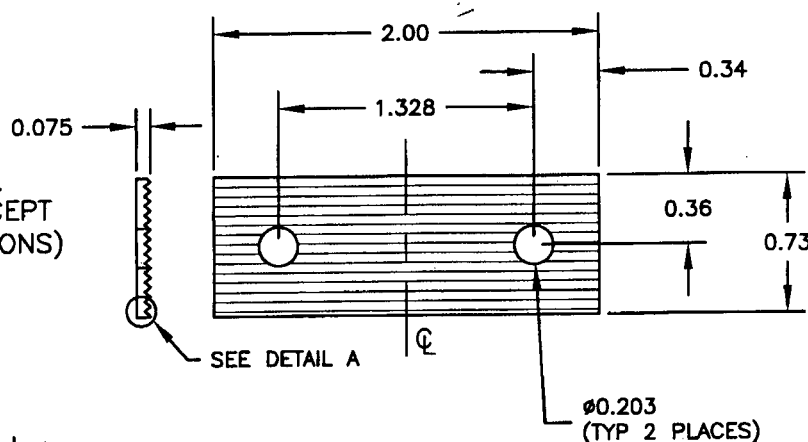
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



| | | | |
|------------------|----------------|---|------------------------|
| DESIGN # | DRAWN BY CB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED CE | APPROVED # | DRAWING NO. D3238 | REV. B SHEET 1 OF 3 |
| DATE 07.01.17 | TITLE PLATE | | SCALE 1:1 |
| A | 03.11.25 | NEW ISSUE | |
| B | 07.01.17 | ADD -21/-23/-25/-31/-33/-35; CHANGE -11/-13/-15 TO 6061-T6 | |

D3238-1 PLATE (SHOWN)
D3238-11 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)



D3238-3 PLATE (SHOWN)
D3238-13 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)

RELEASED

07.01.22 #

NOTES:

- MATERIAL -1/-3/-5/-21/-23/-25 PLATE:
ALUMINUM 2024-T3 SHEET PER QQ-A-250/4 OR AMS 4037
(REF DART SPEC M2024T3S)
-11/-13/-15/-31/-33/-35 PLATE:
ALUMINUM 6061-T6/-T62 SHEET, 0.020 THICK, PER QQ-A-250/11 OR
AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.020)
- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 004 4.1
- BREAK ALL SHARP EDGES 0.005 TO 0.010
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- SEE SHEET 3 FOR DETAIL A
- PARTS ARE SYMMETRIC ABOUT ϕ

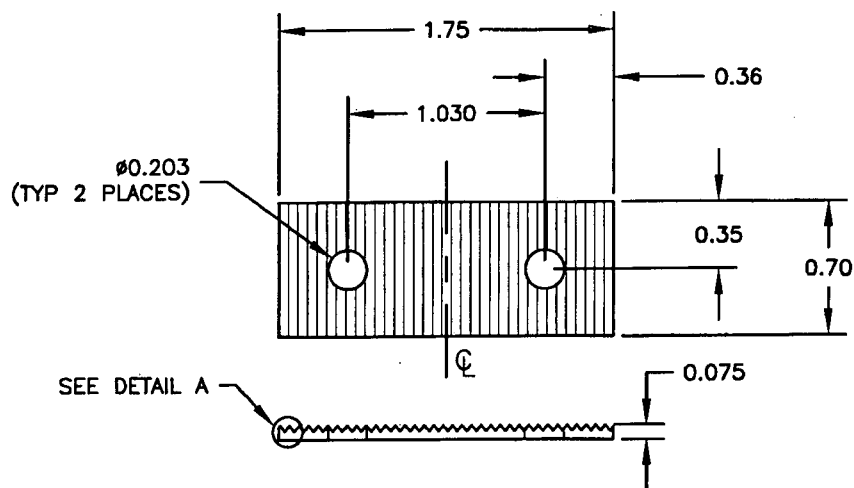
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WORK ORDER
NO. 30744

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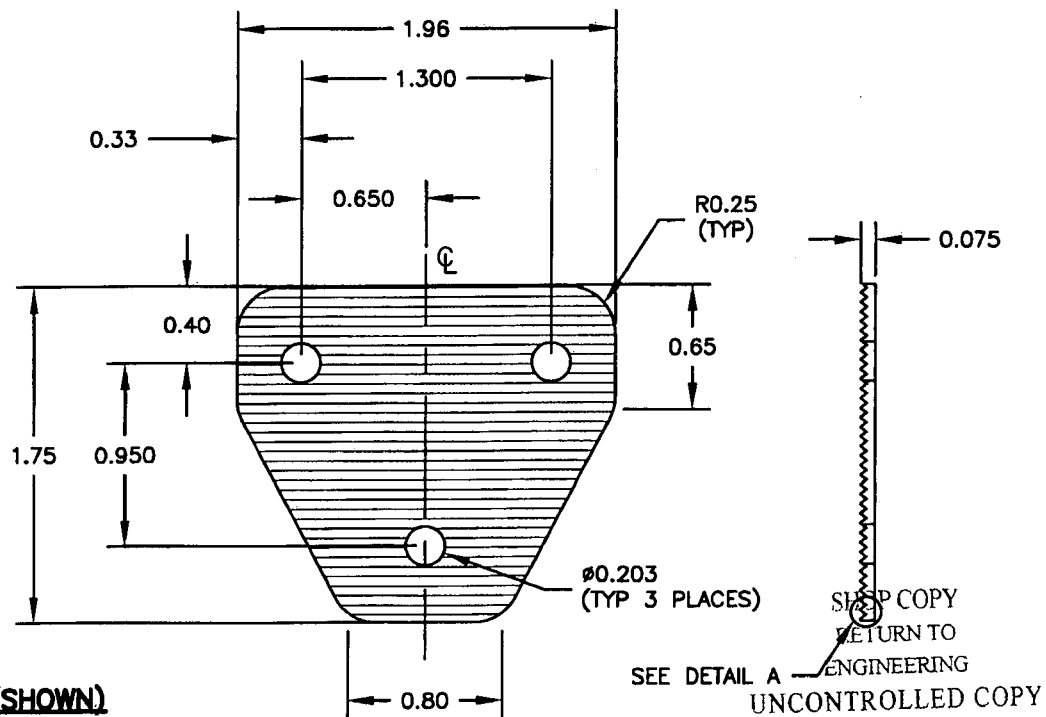
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DART

| | | | |
|------------------|----------------|---|------------------------|
| DESIGN # | DRAWN BY CB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED LE | APPROVED # | DRAWING NO. D3238 | REV. B SHEET 2 OF 3 |
| DATE 07.01.17 | TITLE PLATE | | SCALE 1:1 |

**RELEASED**

07.02.17



D3238-21 PLATE (SHOWN)
D3238-31 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)

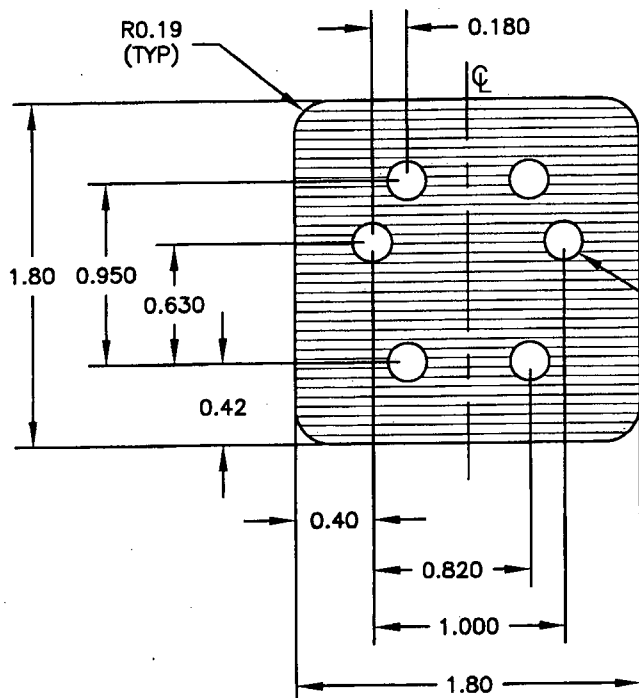
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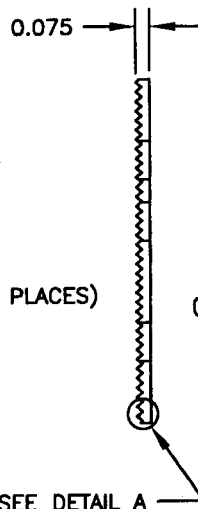
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| CHECKED LE | APPROVED # | DRAWING NO. D3238 | REV. B SHEET 3 OF 3 |
| DATE 07.01.17 | | TITLE PLATE | SCALE 1:1 |



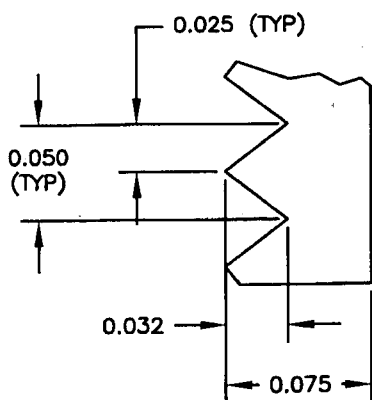
Ø0.203
(TYP 6 PLACES)



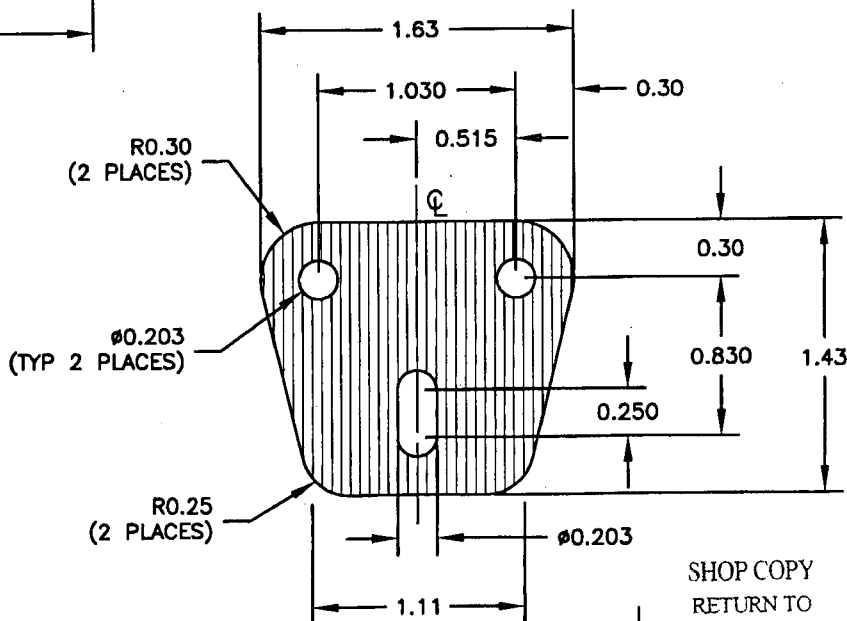
RELEASED

07.01.22

D3238-23 PLATE (SHOWN)
D3238-33 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)



DETAIL A
RIDGE DETAIL (VIEW MAY BE ROTATED)
SCALE 10:1



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30744

D3238-25 PLATE (SHOWN)
D3238-35 PLATE (SAME, EXCEPT
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